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D3286-1

Job Sheet 192258



Part No: D3286-1

Job Qty: 20 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/19

Job Tracking No:

Due Date: 4/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP A 04.07.14 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-06-16 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		4/5/19	0.00	0.78	Waterjet - Flow		2019/04/26
120	QC 8	20 pcs		4/5/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Small Fab - Brake NC - B4B	20 pcs		4/5/19	0.00	0.35	Small Fab - Brake - 1 - B4B		DAS 30 9-89
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 - B4B		

Plex 3/20/19 9:15 AM Dart.lajeunesse.marie

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

Part Op **100** - (Waterjet - Flow)
 Descriptions: **120** - (QC8- Inspect parts - second check)
130 - (Form as per dwg)

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Identify as per dwg & Stock Location:_____)

160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	1.4980 sf (.0749 ea)	100-Waterjet - Flow - 1	5155920

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	1	117	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	5.374inches $\pm$ 0.010	5.384 5.364		
2	Doubler	3.974inches $\pm$ 0.010	3.984 3.964		
3	Doubler	2.000inches $\pm$ 0.010	2.010 1.990		
4	Doubler	1.000inches $\pm$ 0.010	1.010 0.990		
5	Doubler	0.700inches $\pm$ 0.010	0.710 0.690		
6	Doubler	0.188inches + 0.005 - 0.001	0.193 0.187		
7	Doubler	0.125inches $\pm$ 0.010	0.135 0.115		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S176117



Part: D3286-1

Job No: 192258

Serial No/Batch: S176117

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/29/19